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13

: 412 X-TUBE INST, LOW NARROW AFT

: D412664205

: 22/09/2008

: N/A

: C

: D412-664 -245 RE

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Type

S.O. No. :

Job Number

: 41920

Estimate Number

: 12817 P.O. Number

This Issue

: 09/09/2008

: 38489

: NC

Prsht Rev. First Issue : //

Previous Run

Written By

Comment

Checked & Approved By

New Issue 07-04-05 JLM

Est Rev:B 08-06-12 add comment in seg. 24 DD verified

: CROSSTUBES

by:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: DOCUMENT CONTROL

1.0 DC

or JLD 08.9.16

Comment: DOCUMENT CONTRO

Photocopy bluefile and create labels as per PPP D412-664-205 CHG001

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3.0

D412664205TRN

Crosstube Turning Detail



Comment: Qtv.: 1.0000 Each(s)/Unit Total:

CROSSTUBE TURNING DETAILS

batch_1340548

1.0000 Each(s

BENDING MACHINE - SKIDTUBES

DIMENSIONAL PHECK

4.0 BENDING

Comment: BENDING MACHINE

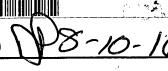
Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

5.0

QC6

Comment: DIMENSIONAL CHECK







W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No:		PAR #: <u>^</u>	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution: _		Disposition:	QA: N/C Closed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)									
	Description of NC	<u>- </u>	Corrective Action Section B		Verification	Approval	Approval			
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Tuesday, 09/09/2008 1:24:18 PM Date: User: Julie Lecocq **Process Sheet** Drawing Name: 412 X-TUBE INST, LOW NARROW AFT Customer: CU-DAR001 Dart Helicopters Services Job Number: 41920 Part Number: D412664205 , Job Number: Seq. #: Description: **Machine Or Operation:** Cuff D36061 6.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) CUFF Batch: CROSSTUBES RESOURCE 1 Comment: LANDING GEAR RESOURCE 1 1-Drill Rivet holes as per Dwg D412-664-245 using DT8972. 85 06-10.20 2-Drill pilot holes in tube as per Dwg D412-664-245 3-Ream hole to finish size in tube as per Dwg D412-664-245 4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-245 HAND FINISHING RESOURCE #1 8.0 / HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat Tube & Cuffs as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION INSPECT WORK TO CURRENT STEP 10.0 QC5 Comment: INSPECT WORK TO CURRENT STEP W 11.0 **OUTSIDE SERV.10 OUTSIDE SERVICES -skids** Comment: Sub-Contracting OUTSIDE SERVICES C208110/24 Liquid Penetrant Inspection as per QSI 038Or Issue P/O: 7442 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

Dart	Aeros	pace	Ltd

W/O:		WC	PRK ORDER C	HANGES		V .			
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Tuesday, 09/09/2008 1:24:18 PM Date: User: Julie Lecocq **Process Sheet** Drawing Name: 412 X-TUBE INST, LOW NARROW AFT Customer: CU-DAR001 Dart Helicopters Services Part Number: D412664205 Job Number: 41920 Job Number: Seq. #: Description: **Machine Or Operation:** PACKAGING 1 PACKAGING RESOURCE #1 12.0 Comment: PACKAGING RESOURCE #1 Inspect for transit damage Ensure copy of NDT results attached to work order. 13.0 QC5 Comment: Inspect for damage & ensure results are as per Dwg D412-664-203 CROSSTUBES RESOURCE 1. 14.0 CROSSTUBES Comment: LANDING GEAR RESOURCE 1 1-Rivet Cuffs as per Dwg D412-6647-245. with Sika flex in Between tube & Cuff BATCH: 109 A/R SIKAFLEX -241/-291 15.0 CR3212407 CHERRY RIVET 44.0000 Each(s) Comment: Qty.: 44.0000 Each(s)/Unit Total: CHERRY RIVET SPRAY PAINTING **Comment: SPRAY PAINTING** 1-Prime inside and outside crosstube as per QSI 005 4.2 08-11-11 2-Paint outside crosstube with White Imron as per QSI 005 4.2 17.0 QC14 INSPECT SPRAY PAINT Comment: Inspect Spray Paint 08:11.12 Wrap in plastic bag to protect from scratches

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Tuesday, 09/09/2008 1:24:18 PM Date: User: , Julie Lecocq **Process Sheet** Drawing Name: 412 X-TUBE INST, LOW NARROW AFT Customer: CU-DAR001 Dart Helicopters Services Part Number: D412664205 Job Number: 41920 Job Number: **Description:** Seq. #: Machine Or Operation: D31891 Chafing Shield 18.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Chafing Shield 08-11-12 Batch: RUBBER CUSHION 19.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) **Rubber Cushion** 08-11-17 Batch: Support D28961 20.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Qty Part number Description Batch Support_ 1 D2896-1 03-11-19 D2856600 Abrasion Strip 21.0 Comment: Qty.: 0.9450 f(s)/Unit Total: 0.9450 f(s) Abrasion Strip 2 X D2856-600-1009 BT 08-11-12 Batch: Clamp(per MIL-DTL-8783C) 22.0 MS2192028 Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Qty Part number Description Batch Clamp 108847 4 MS21920-28 08-11-12 clamp(per MIL-DTL-8783C) 23.0 . MS2192030 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) · clamp(per MIL-DTL-8783C) KI 08 11 13 106810 batch:

Dart	Aeros	pace	Ltd
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Tuesday, 09/09/2008 1:24:18 PM Date: User: , Julie Lecocq **Process Sheet** Drawing Name: 412 X-TUBE INST, LOW NARROW AFT Customer: CU-DAR001 Dart Helicopters Services Job Number: 41920 **Part Number:** D412664205 Job Number: Seq. #: Description: **Machine Or Operation:** CROSSTUBES **CROSSTUBES RESOURCE 1** 24.0 Comment: LANDING GEAR RESOURCE 1 Assemble as per Dwg D412-664-245 1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe 2-Install Chaffing Sheilds 3-Instal support with magnobond 6398 per dwg D412-664-245, using installaition jig DT9024 with 0.010 thick brass shims on both chafing sheild (D3189-1). cure for 12hrs before packaging. Time & date of application: 2100 108966 INSPECT WORK TO CURRENT STEP 25.0 QC5 Comment: INSPECT WORK TO CURRENT STEP 26.0 PACKAGING : PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Pick Packing Kit 27.0 AN640A Bolt Comment: Qty.: 4.0000 Each(s) Total: Bolt Batch: 28.0 AN641A Comment: Qty.: Total: 2.0000 Each(s) Bolt Batch:

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W/O:			WO	RK ORDER CHANG	ES					
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Tuesday, 09/09/2008 1:24:18 PM Date: User: , Julie Lecocq **Process Sheet** Drawing Name: 412 X-TUBE INST,LOW NARROW AFT Customer: CU-DAR001 Dart Helicopters Services Job Number: 41920 Part Number: D412664205 Job Number: Seq. #: Description: **Machine Or Operation:** MS21042L6 Nut 29.0 6.0000 Each(s)/Unit Total: 6.0000 Each(s) Comment: Qty.: Nut M168183 Batch: Washer 30.0 Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s) Washer Batch: QC4 INSPECT 100% KITS FOR COMPLETENESS 31.0 KITS FOR COMPLETENESS Comment: INSPE PACKAGING RESOURCE #1 32.0 PACKAGING 1 Identify and pack for shipping as per PPP D412-664-105 33.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion D417 664205 B41920

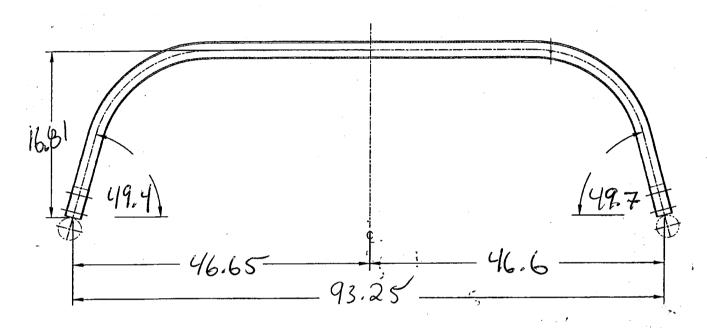
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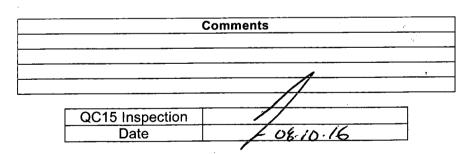
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DART AEROSPACE LTD	Work Order:	41920
Description: Crosstube Low Narrow Aft (412)	Part Number:	D412-664-205
Inspection Dwg: D412-664-245 Rev: C		Page 1 of 1

Required Dimension	Min	Max
Height	16.69	16.95
1/2 Span	46.47	46.73
Angle	49°	52°
Total Span	92.94	93.46





Rev	Date	Change	Revised by	Approved
Α	07.04.27	New Issue	KJ/JM 🔏	fra
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	#	At	D412-664-245 SHEET 1 OF 3
DATE	•		TITLE SCALE
07.0	3.29		CROSSTUBE ASS'Y (412 LOW-N AFT) NTS
Α		06.12.01	NEW ISSUE
В		07.03.01	CHG CUFF AREA, CHG RUBBER CUSHION
С		07.03.29	CHG RIVET AND RUBBER CUSHION

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PARTS LIST:

Qty	Part Number	Description
X	D412-664-245	CROSSTUBE ASSEMBLY (412 LOW-NARROW AFT)
1	D6009-129	CROSSTUBE
2	D2856-600-1009	ABRASION STRIP
1	D2896-1	SUPPORT
2	D3189-1	CHAFING SHIELD
2	D3595-063-570	RUBBER CUSHION
2	D3606-1	CUFF
		,
44	CR3212-4-07	RIVET (OR M7885/3-4-07)
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP (OR MS21920-32)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)
	1	

GENERAL NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

2) MATERIAL: MANUFACTURED FROM D6009-129

FINISHED L'ENGTH = 123.59±0.020 (BEFORE BENDING/TRIMMING)

3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2

4) PART IS SYMMETRIC ABOUT CENTERLINE.

5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD BE SMOOTH.

6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.

7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.

9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF

CROSSTUBE PER QSI 035.

10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1
THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER
INSTALLATION AND PRIOR TO PACKAGING.

PERUNATOR

12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE ENGINEERING D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE ENGINEERING CROSSTUBE SUPPORT.

UNCONTROLLED COP

13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY TO AMENDMENT AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

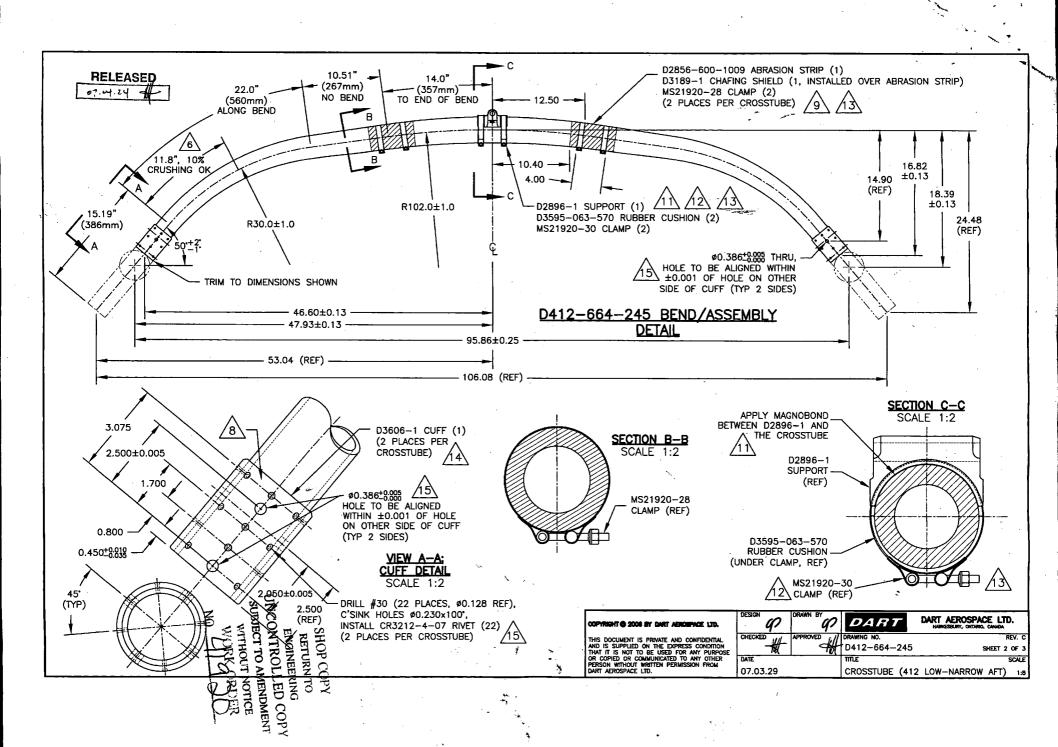
14) INSTALL D3606-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITHWITHOUT NOTICE LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEERK ORDER CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.

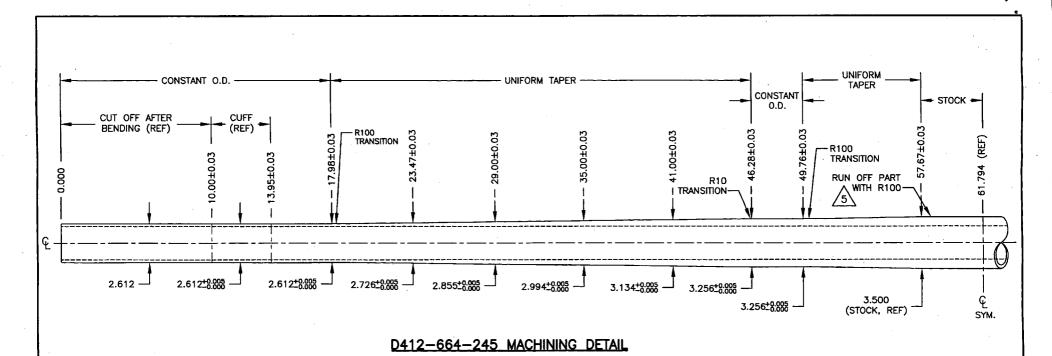
15) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE	CHECKED	APPROVED	DRAWING NO. D412-664-245	REV. C SHEET 3 OF 3
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PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	07.03.29		CROSSTUBE (412	2 LOW-NARROW AFT) 1:4

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LIQUID PENETRANT TEST REPORT

P-09129

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